

NOV 23 2005

Docket No.: HERLA
Appl. No.: 10/820,441**AMENDMENTS TO THE CLAIMS WITH MARKINGS TO SHOW CHANGES
MADE, AND LISTING OF ALL CLAIMS WITH PROPER IDENTIFIERS**

1. (Currently amended) A spindle unit for a machine tool, comprising:
 - a drive unit having a drive shaft;
 - a spindle head assembly ~~constructed for receiving a tool and~~ having a hollow spindle head shaft driven by the drive unit;
 - a tie rod arranged for axial displacement in the hollow spindle head shaft between rearward and forward positions and mechanically coupled with the drive shaft;
 - a collet placed in a pocket of the spindle head shaft and interacting with the tie rod to clamp a tool, when the tie rod assumes the rearward position, and to expel the tool, when the tie rod assumes the forward position; and
 - a shifting unit for axially moving the drive shaft together with the tie rod.
2. (Original) The spindle unit of claim 1, wherein the spindle head assembly and the drive unit are detachably connected to one another, and wherein the drive shaft and the tie rod are detachably coupled to one another.
3. (Original) The spindle unit of claim 1, wherein the spindle head shaft has one end facing the drive shaft and constructed as a spline shaft, said drive shaft having an end face constructed as a hollow wheel to complement the one end of the spindle head shaft and to enable coupling therewith.
4. (Original) The spindle unit of claim 1, wherein the drive shaft has a central bore for transporting a material, said tie rod having a tube extending into the central bore and being removable therefrom.

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5. (Currently amended) ~~[[The]]~~ A spindle unit of claim 4 for a machine tool,
comprising:
a drive unit having a drive shaft;
a spindle head assembly constructed for receiving a tool and having a
hollow spindle head shaft driven by the drive unit;
a tie rod arranged for axial displacement in the hollow spindle head
shaft and mechanically coupled with the drive shaft; and
a shifting unit for axially moving the drive shaft together with the tie rod,
wherein the tie rod has a central bore for transporting a material, said
drive shaft having a tube extending into the central bore and being
removable therefrom.
6. (Original) The spindle unit of claim 1, wherein the drive shaft is constructed
in one piece with the tie rod.
7. (Original) The spindle unit of claim 1, wherein the drive unit includes an
electric motor having a rotor mounted on the drive shaft.
8. (Original) The spindle unit of claim 7, wherein the electric motor includes a
stator which completely surrounds the rotor independent of a displacement
position of the shifting unit.
9. (Original) The spindle unit of claim 1, and further comprising an axially
displaceable bearing assembly for support of the drive shaft.
10. (Original) The spindle unit of claim 9, wherein the drive shaft has opposite
ends, said bearing assembly having a bearing sleeve for support of one end
of the drive shaft, and another bearing sleeve for support of the other end of
the drive shaft.

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11. (Original) The spindle unit of claim 1, wherein the shifting unit is constructed for operation by one of hydraulic means, pneumatic means, and electromechanical means.
12. (Original) The spindle unit of claim 1, wherein during operation of the spindle unit, the shifting unit is controlled so as to cause the drive shaft to axially contact the tie rod, and further comprising a sensing device constructed for measuring an axial position of the drive shaft and thereby implementing an indirect measurement of an axial position of the tie rod.
13. (Currently amended) A method for operating a spindle unit for a machine tool having a drive unit with a drive shaft and a spindle head assembly for ~~receiving a tool~~ with a tie rod, comprising the steps of:
 - placing a tool in a collet received in the spindle head assembly;
 - moving the drive shaft backwards in axial direction to shift the tie rod into a rearward position to thereby cause the collet to clamp the tool; and
 - moving the drive shaft forward in axial direction to shifting ~~shift~~ the tie rod in axial direction to a first forward position with the help of the drive shaft to thereby expel the tool from the collet[[: and]]
 - ~~moving the drive shaft backwards in axial direction to a second position, thereby also enabling a backward movement by the tie rod.~~
14. (Currently amended) The method of claim 13, wherein during operation of the spindle unit the drive shaft axially bears upon the tie rod, further comprising the step of so as to allow indirect measurement of indirectly measuring a position of the tie rod ~~on the basis of~~ for ascertaining the position of the drive shaft.